

Date: Tuesday, 1/23/2007 7:31:05 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CLAMP
Job Number	30373	Part Number	D1048
Estimate Number	10584	Drawing Number	D1048 REV A
P.O. Number	N/A	Project Number	N/A
This Issue	1/23/2007	Drawing Revision	A
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	2/10/2007
Previous Run	29769	Qty:	50
Written By		Um:	Each
Checked & Approved By	<u>DK</u> 07/01/23		
Comment	Est: B 02/02/22 Re-format NG Est Rev:C Now on Waterjet 06-12-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
	Comment: Qty.: 0.0116 sf(s)/Unit Total : 0.5775 sf(s) 304/316 .063 Sheet Batch: M101873	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D1048 Dwg Rev: A Prog Rev: A	<i>SAD 07/01/28</i>
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SAD 07/01/28</i>
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<i>M07/01/29 (SD)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.	<i>FF 07-02-09 50</i>

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/22
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

FF

07-02-09

50

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP

07/02/09

50

8.0 POWDER COATING POWDER COATING



m100760

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FF/4

07/02/13

50

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC/1/2/20 (50)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: st

PC/1/2/20

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PC/1/2/20

50

Job Completion



10/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
97/09/02 B&W

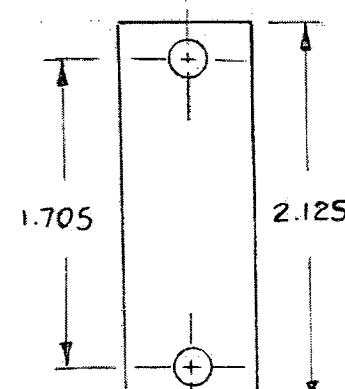
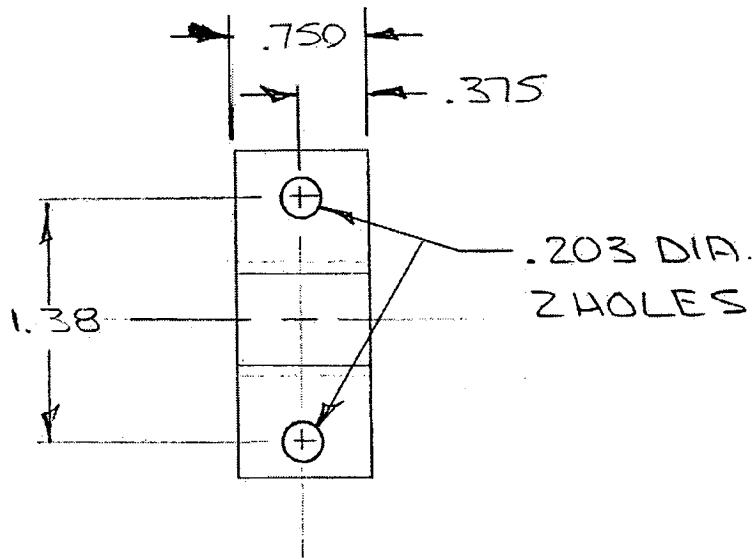
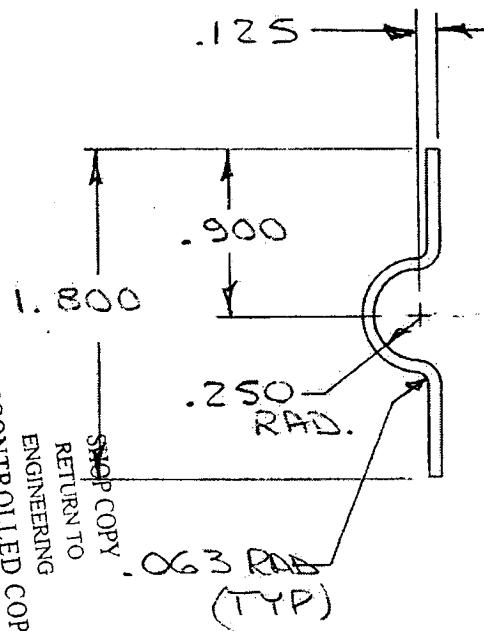
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



FLAT PATTERN

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 30373

SHOP COPY
RETURN TO

ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
RF	DRAWN			BASIC CODE	01A DASH NO. #1 HEAD REAR SIDE #1 HEAD F/R SIDE	CONTRACT NO.	DART AERO ACCESSORIES INC. VANCOUVER		
	APPROVED			01A DASH NO. #1 HEAD REAR SIDE #1 HEAD F/R SIDE	LENGTH DASH NO. #1 SPOTWELD	DRAWN BY	DART		
	DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		01A DASH NO. #1 HEAD REAR SIDE #1 HEAD F/R SIDE	LENGTH DASH NO. #1 SPOTWELD	DESIGN BY	DART		
		GENERAL	DETAILS	01A DASH NO. #1 HEAD REAR SIDE #1 HEAD F/R SIDE	LENGTH DASH NO. #1 SPOTWELD	STRESS	CLAMP		
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS #11 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH 5-7742 5. HOLES PER INCH 10007	1. TOLERANCES - .000 -.000 2. ANGLES .00075 3. PARALLELISM .00075 4. ECCENTRICITY .0005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	BASIC CODES 85-MSP047040 86-MSP042640		CHECKED	CLAMP		
		REPORT ALL DISCREPANCIES - DO NOT SCALE				CLIENT	CODE	DWG NO.	REV.
								D 1048	A
							SCALE	1:1	SHT 1 OF 1



D 1048

A

DART AEROSPACE LTD	Work Order:	30373
Description:	Part Number:	D1048
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: <u>SAD</u>	Audited by: <u>SG</u>	Prototype Approval: _____
Date: <u>07/01/28</u>	Date: <u>07.01.28</u>	Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	